

Work Order ID 60456

Friday, July 09, 2010 9:54:27 AM

Page 1

Item ID: D3763-041

Accept

Revision ID:

Item Name: End Fitting Assembly

Start Date: 7/12/2010 Start Qty: 4.00

Required Date: 7/16/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: *MF*Date: *10-7-9*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3763

Rev B

100

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

110

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-make a 0.063" chamfer on D3763-1 fitting before ass'y
2-assemble as per dwg D3763 using locating pin DT9039
*****ensure locating pin is in 0.221" hole*****
3-weld as per dwg D3763 QSI004 Alum.
rod Batch: *1113385*

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

*Rpl 10-07-12**Rpl 10-07-12**④ 10.07.13*

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Page 2

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Revision ID:

Item Name: End Fitting Assembly

Start Date: 7/12/2010 Start Qty: 4.00

Required Date: 7/16/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

8.10.07.13



QC

Memo

0.00

Quality Control

X40

140

Chemical Conversion Coat per QSI005 4.1

0.00

H



HandFinish

Memo

0.00

Hand Finishing

H BR 10-7-14.

150

QC3- Inspect Part Finish

0.00

H



QC

Memo

0.00

Quality Control

X41

| W/O: | | | WORK ORDER CHANGES | | | | | |
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Work Order ID 60456

Friday, July 09, 2010 9:54:27 AM



Page 3

Item ID: D3763-041

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly

Start Date: 7/12/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 7/16/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 251

0.00



Packaging

Memo

0.00

Packaging

6/22/14 (4)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

100715
MF 10-7-14

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NOTE: Date & initial all entries

Picklist Print

Friday, July 09, 2010 9:54:26 AM

Page 1

Work Order ID: 60456

Parent Item: D3763-041

Parent Item Name: End Fitting Assembly



Start Date: 7/12/2010

Required Date: 7/16/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC
IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3763-1  End Fitting | | Manufactured | No | | | 110 | Each | 5.0000 | 1 | 4 | | | |
| <div> <div>Location</div> <div>WA</div> <div>56755</div> </div> <div> <div>Loc Qty</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> </div> | | | | | | | | | | | | | |
| D3763-3  Tube | | Manufactured | No | | | 110 | Each | 6.0000 | 1 | | | | |
| <div> <div>Location</div> <div>ST251</div> <div>56597</div> <div>57553</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>2</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> </div> | | | | | | | | | | | | | |

Cpl 1007.12

4

Cpl 1007.12

22

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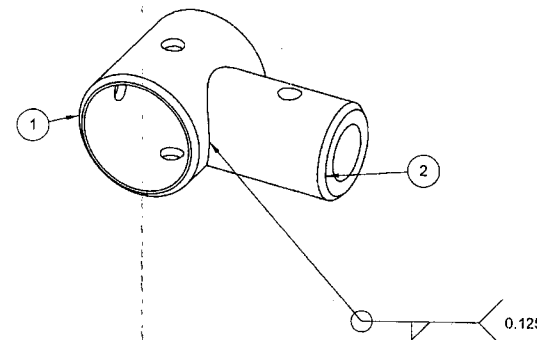
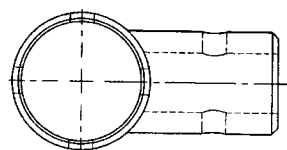
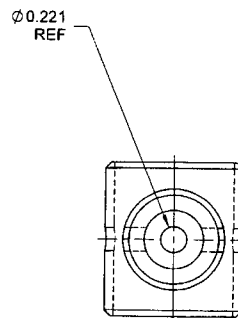
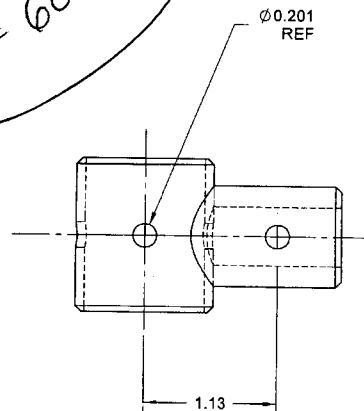
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NOTE: Date & initial all entries

60456



| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. (-041) |
|----------|-------------|-------------|-------------|
| 1 | D3763-3 | TUBE | 1 |
| 2 | D3763-1 | FITTING | 1 |

D3763-041 END FITTING ASSY

RELEASED
08.07.10 MPD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs
- 8) WELD: PER DART QSI 004

| | | | |
|------------|--|---|--------------|
| B | CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY | HS | 08.06.23 |
| A | NEW ISSUE | HS | 08.06.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | DART AEROSPACE LTD | |
| DRAWN | HS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3763 | SHEET 1 OF 9 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | END FITTING | NTS |
| DATE | 08.06.23 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

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